

Work Order ID 68581

Monday, April 18, 2011 9:28:34 AM



Page 1

Item ID: D4148-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Plate, Fwd

Start Date: 4/18/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 4-18-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4148

D

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D4148

Prog Rev: 2

Dwg Rev: 2

Deburr as required

BH-4-24

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

BH-4-26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4148-1 PAR #: N/A Fault Category: Prod Eng Good NCR: Yes No DQA: A Date: 11.05.02
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: CK Date: 11/05/03

NCR: <u>368581</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/04/27	# 100	Found during inspection that Qty x3 Parts have 1 of the .375" hole max .43" (the hole with edge distance of 1.23") R.C. Programmer LOR.	<u>11.04.27</u> <u>Q51042</u>	-7 check program to ensure no issues. Scrap + Destroy Qty x3 no Replng	<u>11.04.27</u> <u>11-4-27</u>	<u>S</u> <u>11/04/27</u>	<u>11.04.27</u> <u>Q51042</u>	<u>S</u> <u>11/04/27</u>

NOTE: Date & initial all entries

Work Order ID 68581

Page 2

Monday, April 18, 2011 9:28:34 AM

Item ID: D4148-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Plate, Fwd

Start Date: 4/18/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Suck 2

+17

x3

150

Identify as per dwg & Stock Location: 133

0.00



Packaging

Memo

0.00

Packaging

11/4/27 SP

132

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/28

MF
11-04-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, April 18, 2011 9:28:41 AM

Page 1

Work Order ID: 68581



Parent Item: D4148-1



Parent Item Name: Crosstube Lug Plate, Fwd

Start Date: 4/18/2011



Required Date: 4/21/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.10.29 as per revC DD verf:EC
11.03.02 AS PER DWG REV.D DD VERF:EC

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 		Purchased	No					100	sf	3.7500	0.3607	7.593684	
											HB11-4-26		
304/316 0.125 Sheet													

Location

Loc Qty

Loc Code

MAT020

3.75

116623

3.75

117494

60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	68581
Description: Fwd Crosstube Lug Plate		Part Number:	D4148-1
Inspection Dwg: D4148 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.133	X		V B02	
Ø0.191	+0.005/-0.001	.192	X		V	
Ø0.38	+0.006/-0.001	.379	X		V	
Ø0.257	+0.006/-0.001	.256	X		V	
Ø0.50	+0.008/-0.001	.502	X		V	
0.94	+/-0.030	.94	✓		V	
4.47	+/-0.030	4.472	X		V	
0.750	+/-0.010	.754	X		V	
8.47	+/-0.030	8.482	X		BROWS 02	
8.096	+/-0.010	8.096	X		V	
5.43	+/-0.030	5.429	X		V	
5.197	+/-0.010	5.196	✓		V	
4.733	+/-0.010	4.730	X		V	
0.310	+/-0.010	.310	X		V	
0.750	+/-0.010	.749	X		V	
0.375	+/-0.010	.377	X		V	
1.84	+/-0.030	1.839	X		V	
0.92	+/-0.030	.920	X		V	
3.000	+/-0.010	3.000	X		V	
0.750	+/-0.010	.753	X		V	
0.625	+/-0.010	.628	X		V	
1.982	+/-0.010	1.983	X		V	
0.991	+/-0.010	.993	X		V	
0.77	+/-0.030	.767	X		V	
1.54	+/-0.030	1.540	X		V	
2.47	+/-0.030	2.468	X		V	
0.82	+/-0.030	.823	X		V	
3.57	+/-0.030	3.573	X		V	
1.23	+/-0.030	1.236	✓		V	
0.73	+/-0.030	.731	X		V	
0.125	+/-0.010	.117	X		V	

Measured by:	IB	Audited by:	D	Preliminary Approval:	
Date:	11-4-26	Date:	11/04/27	Date:	

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	10.10.08	Dwg Rev updated	KJ	
C	10.11.05	Dimensions updated per Dwg Rev C	KJ	
D	11.03.08	Dwg Rev updated	KJ	

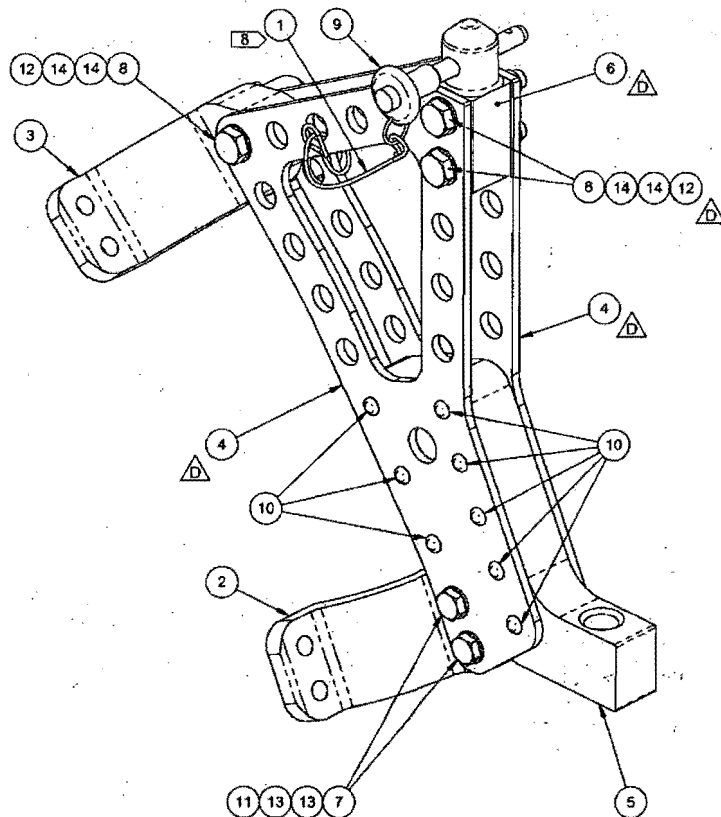
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4148-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
- 7) WEIGHT: 3.67 lbs
- 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68381
R11-07-18

ITEM	QTY	P/N	DESCRIPTION
	X	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	2	AN3C12A	BOLT
8	3	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	8	MS20615-4M18	RIVET
11	2	MS21043C3	NUT
12	3	MS21043C4	NUT
13	4	NAS1149C0332R	WASHER
14	6	NAS1149C0432R	WASHER

RELEASED
R 2011-02-24

D	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.250" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D9-1, C4-2)	SC	11.02.22
C	REDESIGNED D4148-1/3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-591 SHORT STEPS	MB	10.10.12
B	REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); Ø 0.101 2 PL REPLACES Ø 0.129 3 PL (ZN D8-3); Ø 0.129 7 PL WAS 10 PL (ZN A7-3); Ø 0.101 WAS 0.129 (ZN C8-5). REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
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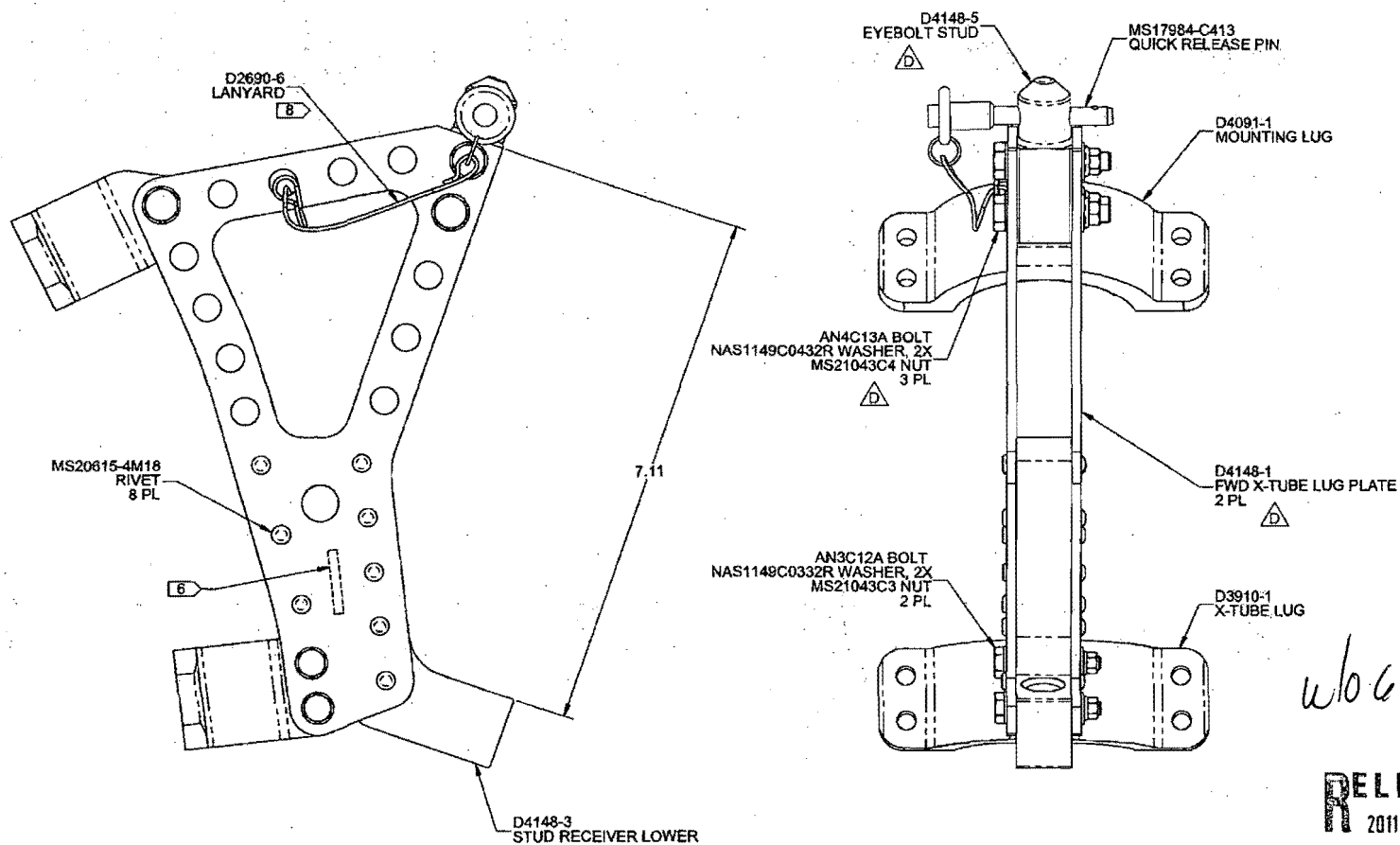
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4148-041 FWD X-TUBE LUG ASSY

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2011-02-24

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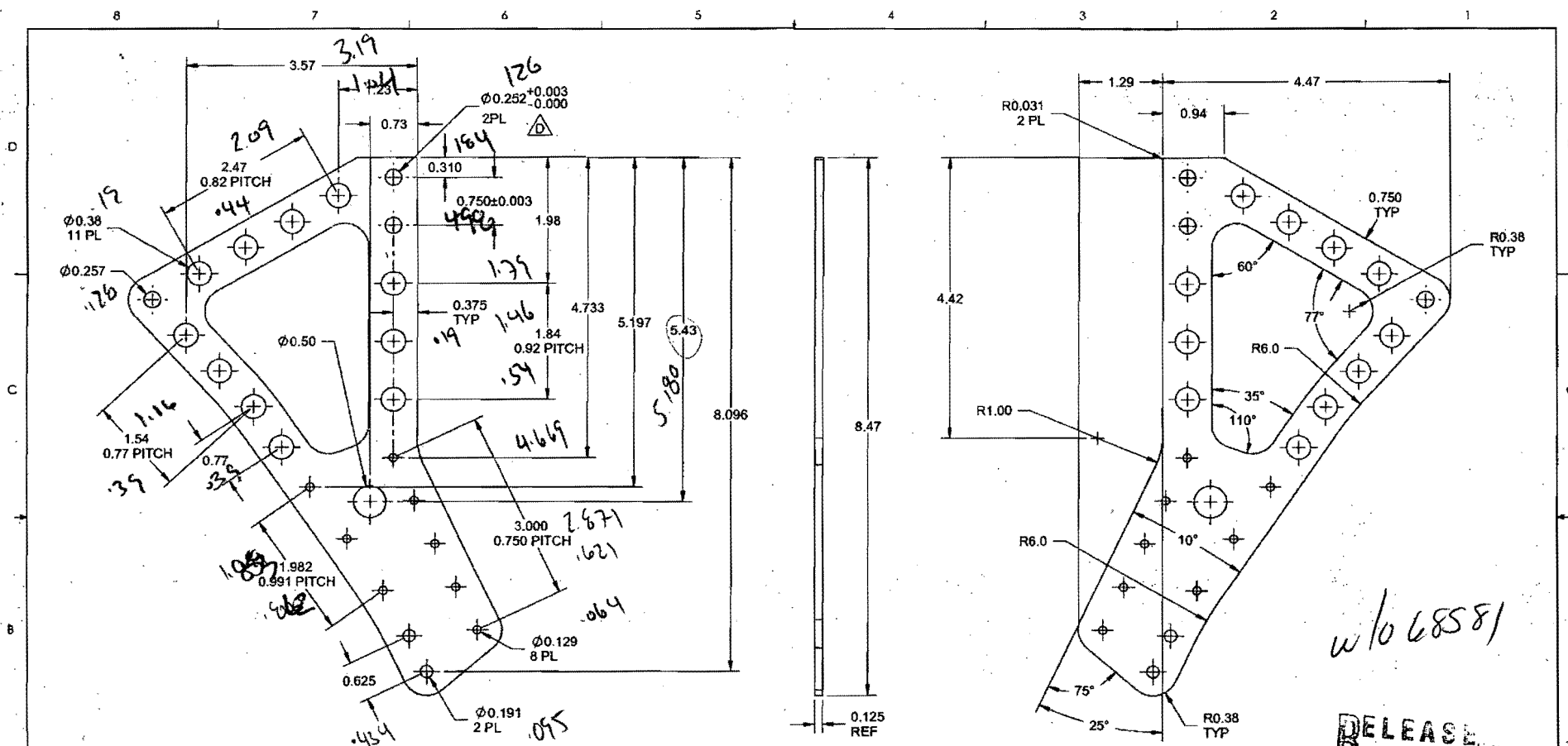
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4148-1 FWD X-TUBE LUG PLATE

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5058 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.52 lbs

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w/068581

RELEASE
R 2011-02-21
JNP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

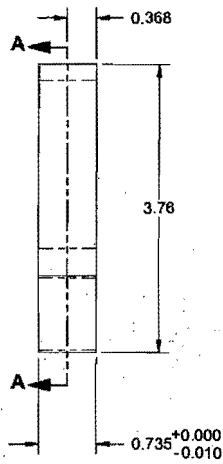
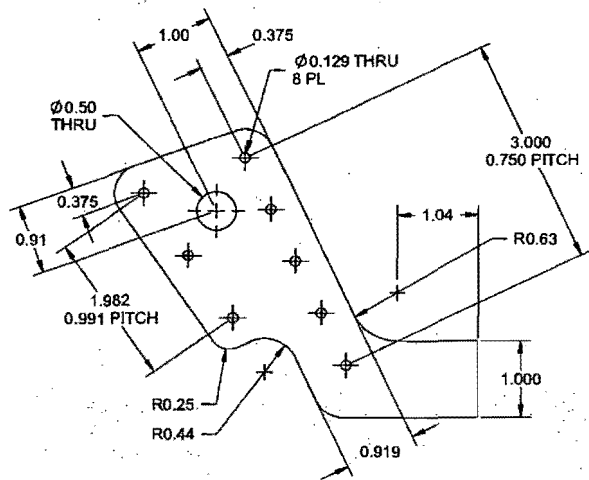
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

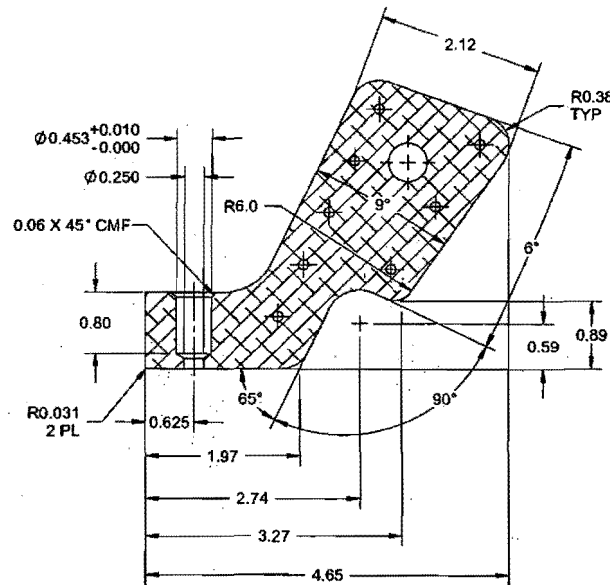
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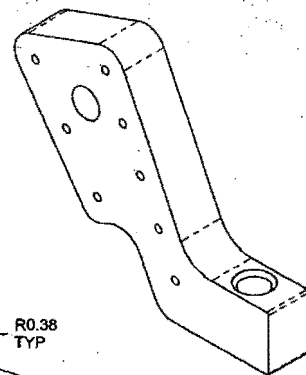
8 7 6 5 4 3 2 1



D4148-3 STUD RECEIVER LOWER






SECTION A-A



w/0 68581

RELEASED
2011-02-31

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.52 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4148	SHEET 4 OF 5
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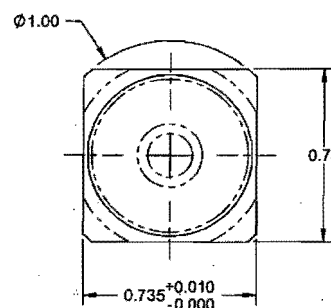
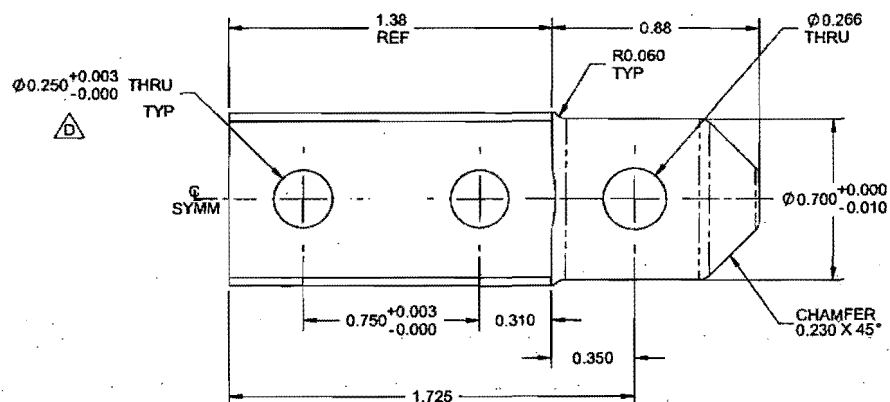
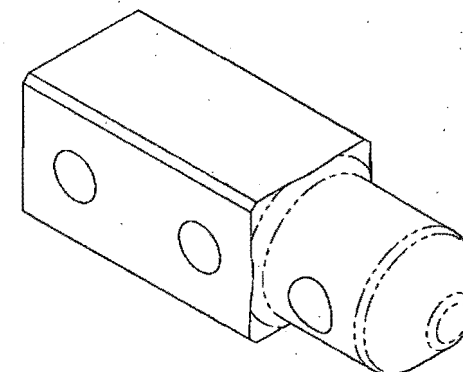
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4148-5 EYEBOLT STUD

wb 68581

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.27 lbs

DESIGN	MB	DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
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